

Work Order ID 87072

87072

Page 1

July-10-12 2:50:09 PM

Item ID: D412-742-043

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Replacement Float Skidtube

Stop

NS2

Start Date: 7/10/12 **Start Qty:** 1.00

1

Cust Item ID:

Required Date: 8/31/12 **Req'd Qty:** 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

J

Date: *7/07/11*

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3391	I

100

0.00

100

DOCUMENT CONTROL

DC

Document Control

Memo

0.00

If D412-742-043 is a W/O on its own,
Photocopy bluefile and create labels per PPP D412-742-043 CHG005

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

110

HandFinish

Hand Finishing

0.00

1x 4 M 11/08/2011

Memo

0.00

1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/RSikaflex-241/291 11122443
Expiry date: 13103

2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube, hand tighten only bolts with no sikaflex.

A/RSikaflex-241/291 11122443
Expiry date: 13103

3-Remove "T" pins once sikaflex is dry.

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

A/RLPS Procyon 1114591

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Page 3

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Cust Item ID:

Required Date: 8/31/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

120

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

(DAS
16
8-3)

2/08/74

130

130

Packaging

Packaging

0.00

PPP 81091

12/8/29/0

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D412-742-043

Location: _____

PPP Rev: _____

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

MUS 12108130

MF
12-08-30

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Picklist Print

July-10-12 2:50:08 PM

Page 1
3

Work Order ID:	87072	Start Date:	7/10/12	Required Date:	8/31/12
Parent Item:	D412-742-043	Start Qty:	1.00	Required Qty:	1.00
Parent Item Name:	Replacement Float Skidtube				
Comments:	IPP Rev A 05.10.13 New Issue KJ/JLM IPP Rev 06.02.13 ECN 773 dwg @ rev.D EC IPP Rev:C 07-05-28 As per Rev F JLM IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM IPP Rev:E 08-09-08 ecn 08-510 DD verified by:EC REV.B DD verified by:EC IPP Rev:F 11.11.01 as per DSI9517				

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3391-021 Fwd Tube Assembly		Manufactured	No			110	Each	0.0000		1	1383866	(x1)	M 17/08/12
D3391-023 Mid Tube Assembly		Manufactured	No			110	Each	2.0000		1	1385168	(x1)	M 17/08/12
					<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
					FP		3						
					83625		1						
					GA		-1						
					85163		1						
D3391-025 Aft Tube Assembly		Manufactured	No			110	Each	2.0000		1	13841703	(x1)	M 17/08/12
					<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
					FP001		2						
					84702		1						
					86183		1						
AN3C4A BOLT		Purchased	No			110	Each	3,664.0000		24	24		M 17/08/12
					<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
					ST350		3664						
					120187		31						
					120521		28						
					120769		38						
					121205		67						
					121556		8						
					122151		3492						V74

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July-10-12 2:50:08 PM

Page 2

Work Order ID: 87072

Parent Item: D412-742-043

Start Date: 7/10/12

Required Date: 8/31/12

Parent Item Name: Replacement Float Skidtube

Start Qty: 1.00

Required Qty: 1.00

AN3C6A BOLT	Purchased	No	110	Each	269.0000	10	10	<i>M 110812</i>
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<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP001	1	
111982	1	
ST351	268	
111982	2	
116419	23	
116549	2	
116704	12	
117619	10	
117688	1	
117872	5	
118422	13	
119449	21	
120423	3	
120693	118	X10
121682	58	

AN3C7A BOLT	Purchased	No	110	Each	184.0000	4	4	<i>M 1208124</i>
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<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST351	184	
113149	14	
116169	1	
117313	10	
117619	12	
117688	6	
119749	1	
120731	8	
121185	30	X4
121541	2	
122141	100	

Dart Aerospace Ltd

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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July-10-12 2:50:08 PM

Page 3

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Start Date: 7/10/12

Required Date: 8/31/12

Parent Item Name: Replacement Float Skidtube

Start Qty: 1.00

Required Qty: 1.00

AN960C10L
washer

NAS1149C0332R Purchased

No

110 Each

21.0000

38

38

AA122063 (X38) HL 1108124

D4095-041
Wearplate Assembly

Manufactured

No

Location

Loc Qty

Loc Code

ST

21

107534

21

13856161 (x1) HL 1108121

D4095-043
Wearplate Assembly

Manufactured

No

Location

Loc Qty

Loc Code

FP001

9

83809

7

85616

2

1 HL 1 1108124

D4095-045
Wearplate Assembly

Manufactured

No

Location

Loc Qty

Loc Code

FP001

16

83479

7

85615

9

1 HL 1 1108121

July-10-12 2:50:08 PM

Shop Packet Print

Page 3

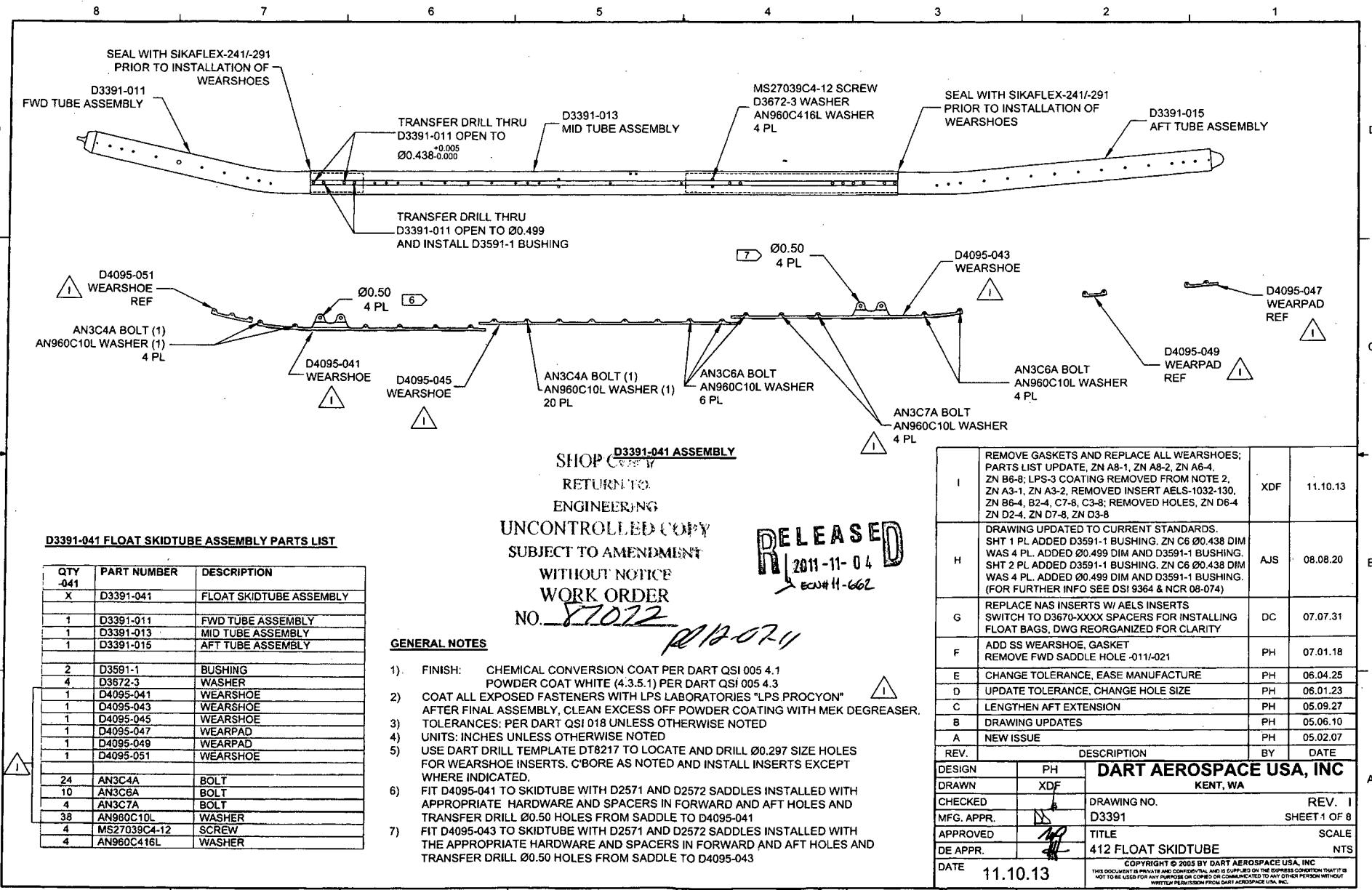
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector,

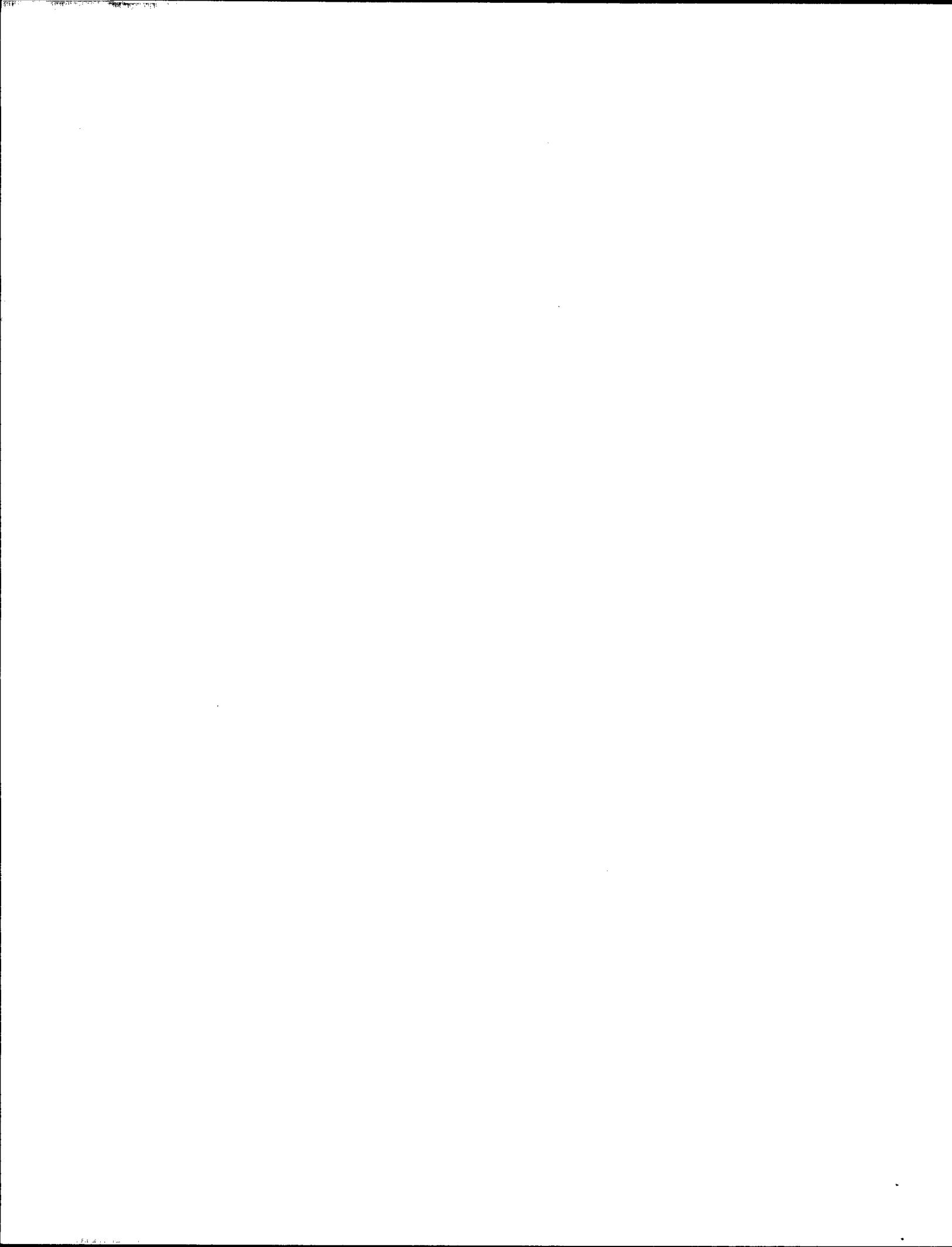
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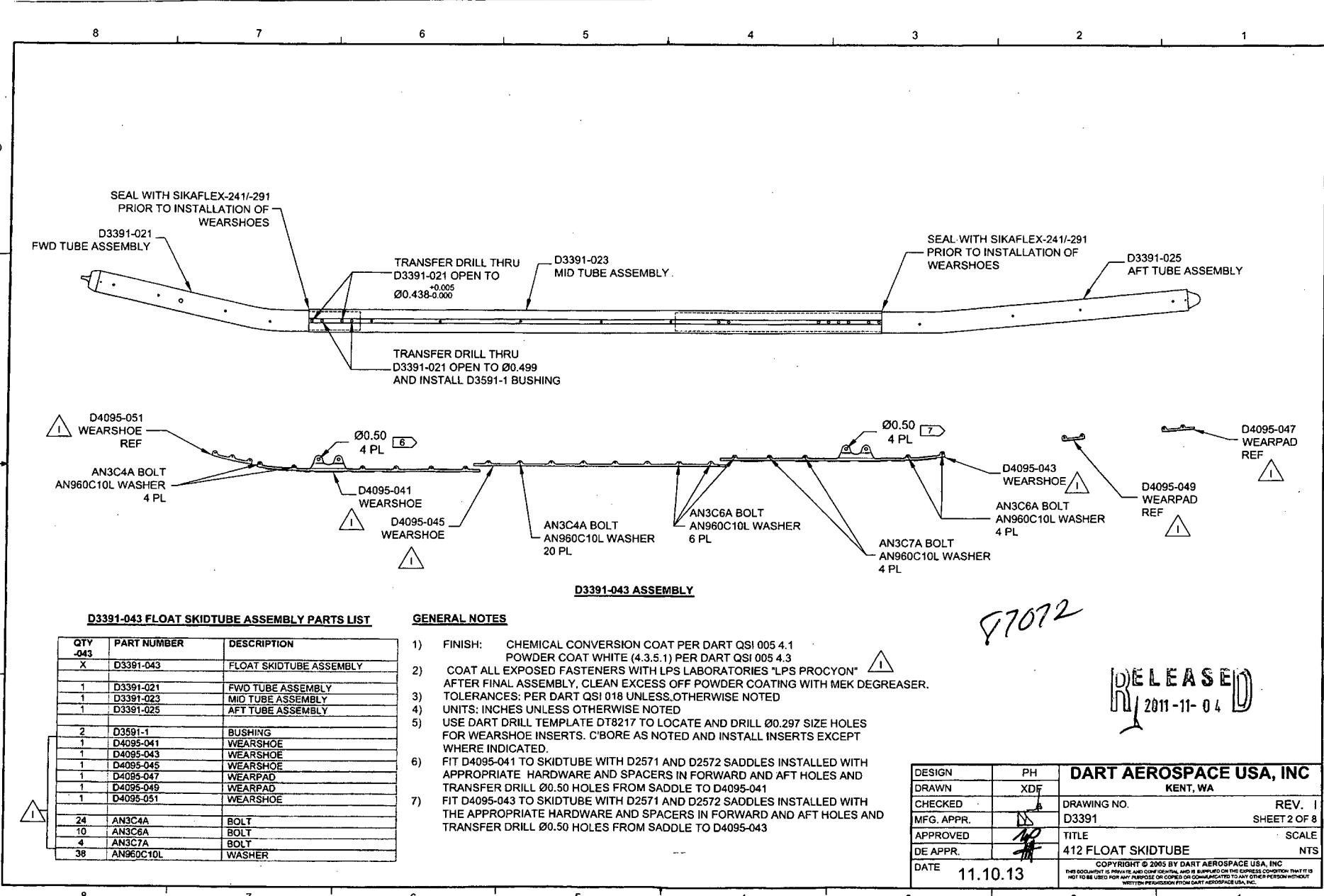
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

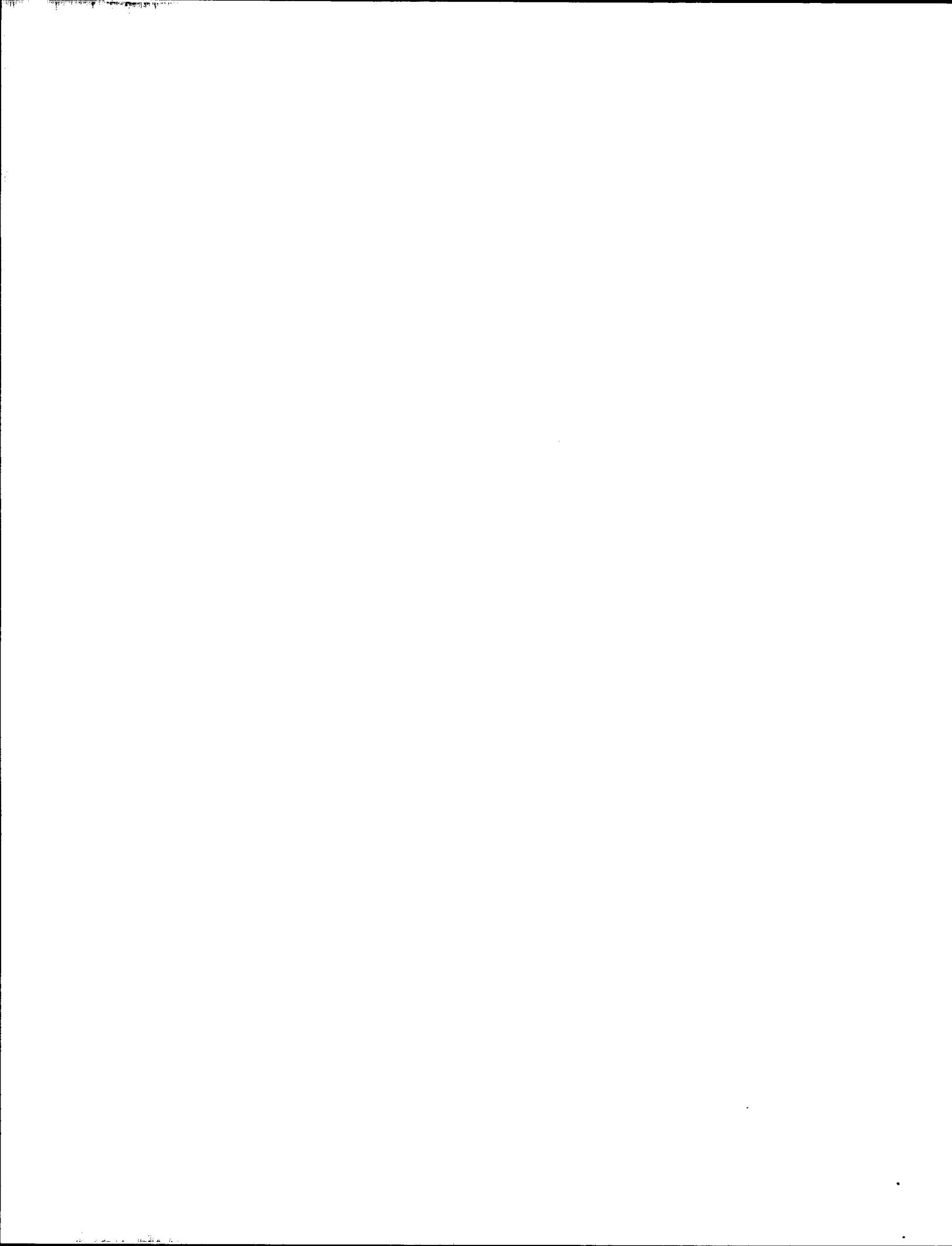
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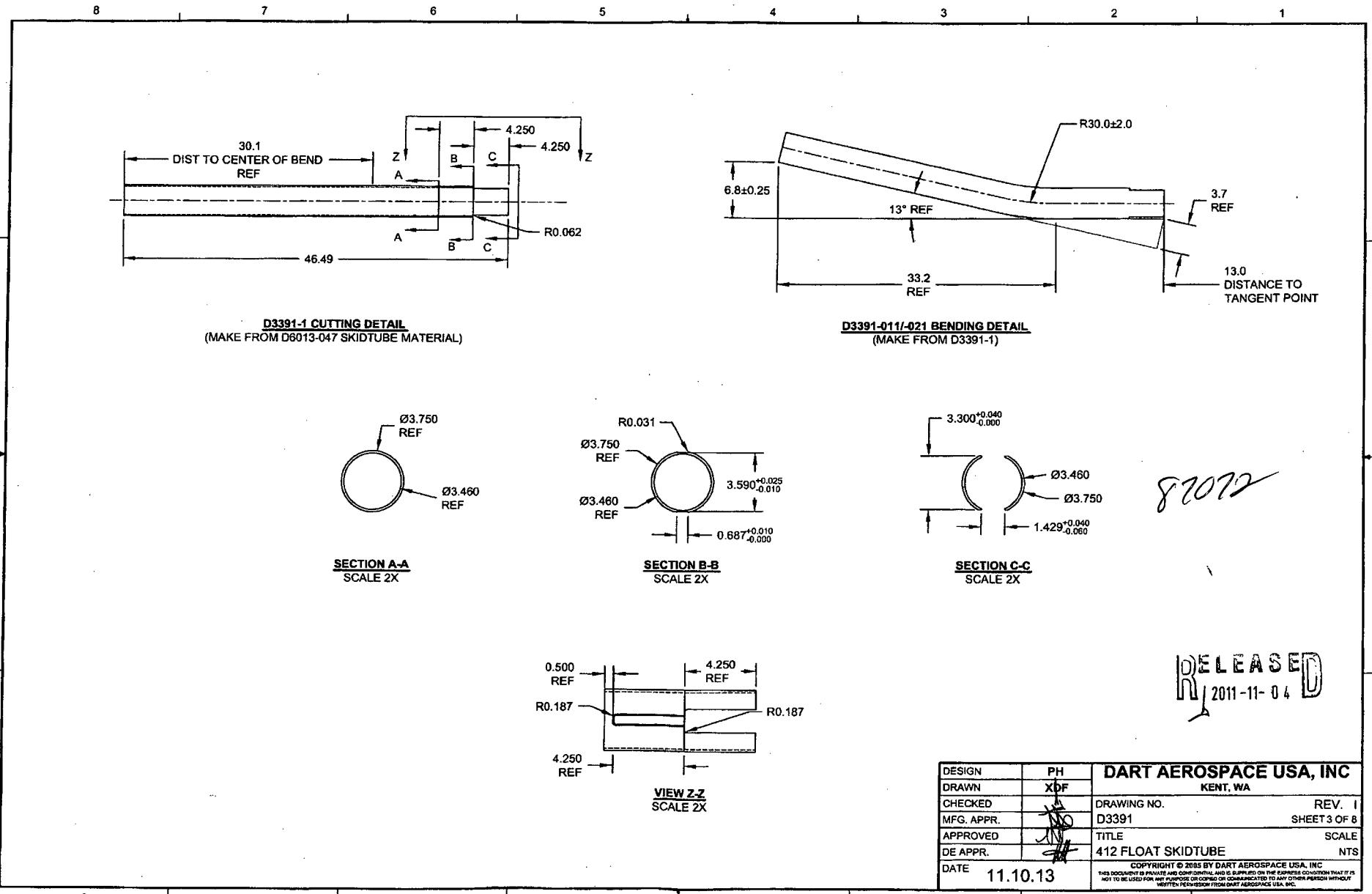
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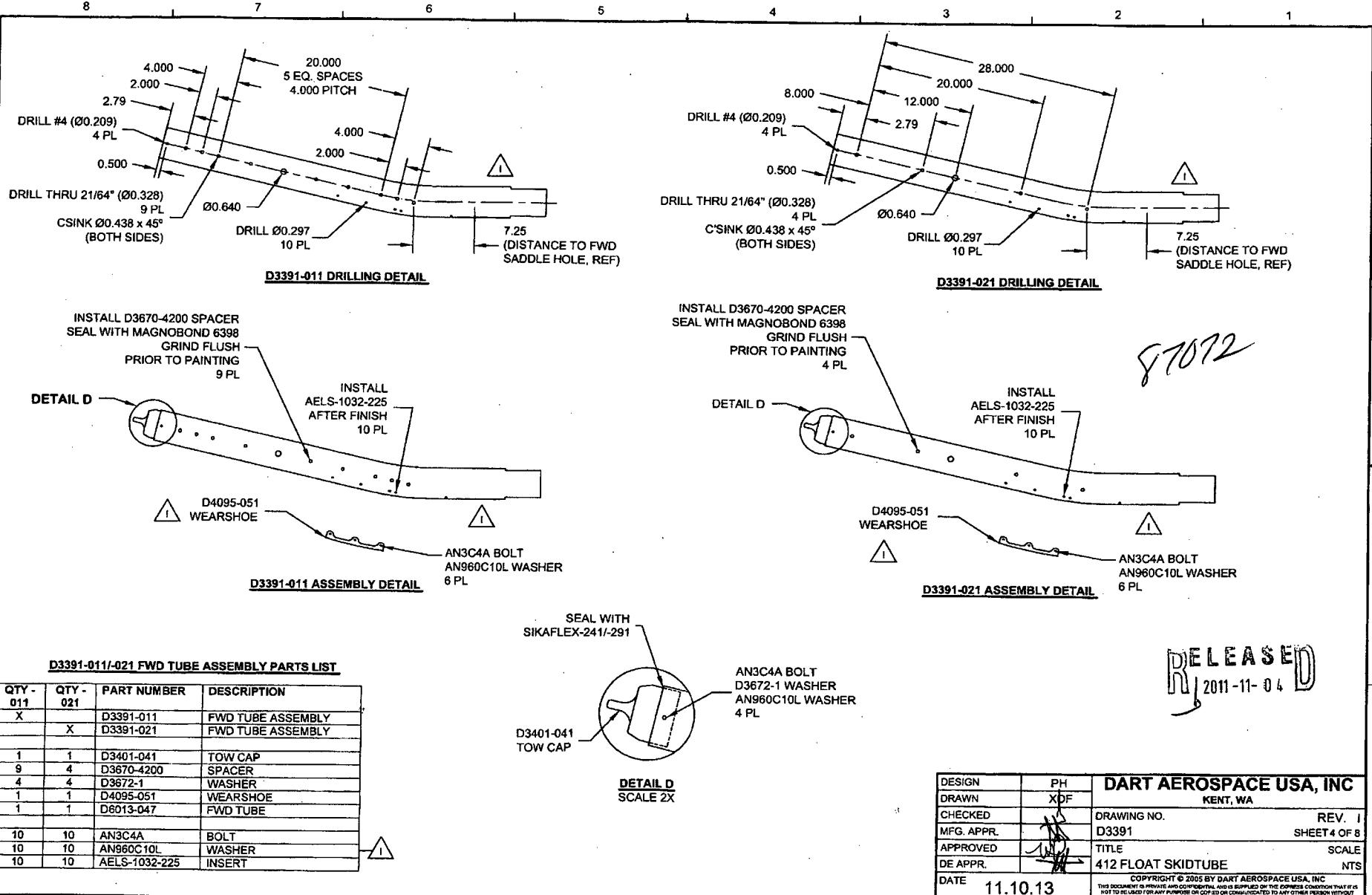




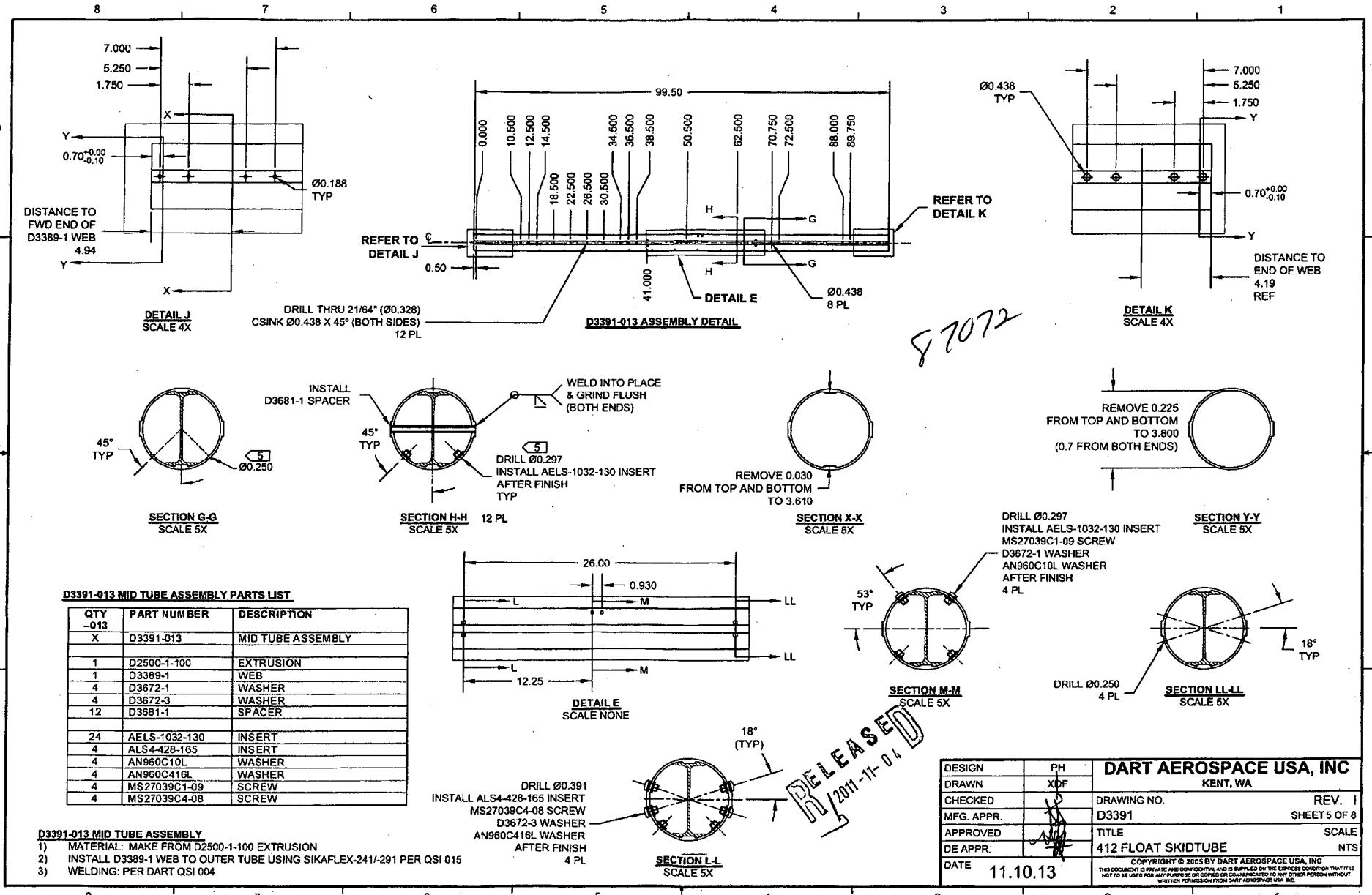












RELEASED
1/2011-11-04



